Dart Aerospace Ltd. Vednesday, 1/25/2006 1:22:00 PM Date: Kim Johnston Liser: **Process Sheet** : SADDLE KIT **Drawing Name** Customer : CU-DAR001 Dart Helicopters Services Job Number : 25618 **Estimate Number** : 10532 : Y/A : K10003 Part Number P.O. Number · K10003 REV B S.O. No. : NIA : 1/25/2006 **Drawing Number** This Issue : N/A : NC **Project Number** Prsht Rev. : NIA : SMALL /MED FAB : B First Issue Type **Drawing Revision** : NIA : 25617 Material **Previous Run Due Date** : 2/20/2006 Qty: 6 Um: Written By Checked & Approved By Reformat: Incorporated D205-641-011 Comment KJ/RF **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: DOCUMENT CONTROL DC 1.0 Comment: DOCUMENT CONTROL Photocopy bluefile and type labels per PPP K10003CHG004 for D205-634-011 and D204-635-011 Bushing 2.0 D2570 24.0000 Each(s)/Unit Total: 144.0000 Each(s) Comment: Qty.: Bushing Pick: Description Qty Part Number 24 D2570 Bushing 3.0 D2571 Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Saddle, Fwd, Out Pick: Part Number Description Batch Qty B 24837 1 D2571 Saddle Saddle, Fwd, In 4.0 D2572

6.0000 Each(s)

Batch

<u>B250</u>17 ~

Description

Saddle

Comment: Qty.:

Saddle, Fwd, In

Pick: Qtv 1.0000 Each(s)/Unit Total:

Part Number

D2572

Each

Dart Aerospace Ltd

W/O:		WORK ORDER CHA	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:					

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Verification		Ι				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
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Date: ' Wednesday, 1/25/2006 1:22:00 PM Kim Johnston User: **Process Sheet** Drawing Name: SADDLE KIT Customer: CU-DAR001 Dart Helicopters Services Part Number: K10003 Job Number: 25618 Job Number: Seq. #: **Description:** Machine Or Operation: Saddle, Aft, Out D2573 5.0 6.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Saddle, Aft, Out Pick: Description Batch / S X B 250/8 Part Number Qty 1 D2573 Saddle D2574 6.0 6.0000 Each(s) 1.0000 Each(s)/Unit Total: Comment: Qty.: Saddle, Aft, In Pick: Part Number Description Batch Qty Saddle 1 D2574 D27361 Lug Assembly 7.0 1.0000 Each(s)/Unit Total: Comment: Qty.: 6.0000 Each(s) Lug Assembly Pick: Qty Part Number Description Batch B24896 D2736-1 Bracket 1 D27363 Lug Assembly 8.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Lug Assembly Pick: Description Batch Qty Part Number <u>BQY</u>375 1 D2736-3 **Bracket** D2747 9.0 Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s) Set Screw Pick: Batch Description Qty Part Number <u>125</u>011 4 D2747 Socket Head Set Screw

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W/O:			WO	RK ORDER CHANGES	3				
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		Description of NC	Corrective Action Se		Veritication Approva			Approval	Anneval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Approval Chief Eng	Approval QC Inspector
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Wednesday, 1/25/2006 1:22:01 PM Date: ` User: Kim Johnston **Process Sheet** Drawing Name: SADDLE KIT Customer: CU-DAR001 Dart Helicopters Services Part Number: K10003 Job Number: 25618 Job Number: Description: Seq. #: **Machine Or Operation:** Saddle Spacer 10.0 D2876 Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s) Saddle Spacer Pick: Description Batch Qty Part Number 2 D2876 Spacer 11.0 D2877 2.0000 Each(s)/Unit Total: 12.0000 Each(s) Comment: Qty.: Saddle Spacer Pick: Batch B22979 Description Qty Part Number 2 D2877 Spacer D2968041 12.0 6.0000 Each(s) Total: Comment: Qty.: 1.0000 Each(s)/Unit Tow Ring Pick: Qty Part Number Description 1 D2968-041 Tow Ring 13.0 AN46A 96.0000 Each(s) Comment: Qty.: 16.0000 Each(s)/Unit Total: Bolt Pick: Qty Part Number Description Bolt M1827 16 AN4-6A AN446A 14.0 Comment: Qty.: Total: 24.0000 Each(s) 4.0000 Each(s)/Unit Bolt Pick: Part Number Description Batch Qty 4 AN4-46A Bolt

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W/O:			N	ORK ORDER CHANG	ES				
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Part No		PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	
					QA:	N/C Close	d:	Date:	
NCR:			WORK ORI	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	NC Corrective Action Section			Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	on C	Chief Eng	QC Inspector
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Date: ` Wednesday, 1/25/2006 1:22:01 PM User: Kim Johnston **Process Sheet Drawing Name: SADDLE KIT** Customer: CU-DAR001 Dart Helicopters Services Part Number: K10003 Job Number: 25618 Job Number: **Description:** Seq. #: Machine Or Operation: Bolt AN451A 15.0 Total: 48.0000 Each(s) Comment: Qty.: 8.0000 Each(s)/Unit Bolt Pick: Description Batch Qty Part Number M18574 Bolt 8 AN4-51A Bolt 16.0 AN612A Total: 48.0000 Each(s) Comment: Qty.: 8.0000 Each(s)/Unit Bolt Pick: Batch Qty Part Number Description 8 AN6-12A Bolt AN960JD416 17.0 32.0000 Each(s)/Unit Total: 192.0000 Each(s) Comment: Qty.: Washer Pick: Qty Part Number Description 32 AN960JD416 Washer AN960JD616 18.0 8.0000 Each(s)/Unit Total: 48.0000 Each(s) Comment: Qty.: Washer Pick: Description Batch Qty Part Number Washer M18367 8 AN960JD616 AN9704 19.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Washer Pick: Batch-Description Qty Part Number M16895 1 AN970-4 Washer

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W/O: WORK ORDER CHANGES											
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Part No)):	PAR #:	:Fault	Category:		NC	R: Yes	No DQ	A: 🕥	<u>)</u> Date: <u> </u>	 663 <i>b</i> 8

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	3.	Verification		Τ		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto		
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Wednesday, 1/25/2006 1:22:01 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: SADDLE KIT Customer: CU-DAR001 Dart Helicopters Services Part Number: K10003 Job Number: 25618 Job Number: Seq. #: Description: **Machine Or Operation:** MS21042L4 20.0 Comment: Qty.: 29.0000 Each(s)/Unit Total: 174.0000 Each(s) Nut Pick: Description Batch Qty Part Number Nut (or MS21042-4)=1 M / 7-99 MS21042L4 29 INSPECT 100% KITS FOR COMPLETENESS QC4 21.0 Comment: INSPEC 100% FOR COMPLETENESS PACKAGING RESOURCE #1 PACKAGING 1 22.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: DOCUMENT CONTROL 23.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

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W/O:			W	ORK ORDER CHAN	GES					
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Part No	:	PAR #:	Fault Cate	gory:	NCF	R: Yes	No DQ	\ :	Date:	
						QA: N	/C Closed	d:	_ Date: _	
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)			
DATE	OTED	Description of NC	Description of NC Corrective Action				Verific	ation	Approval	Approval
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DESIGN DRAWN BY			DART AEROSPAC HAWKESBURY, ONTARIO, C	
CHE	CKED	APPROVED	DRAWING NO.	REV. B
	P	4	K10003	SHEET 1 OF 1
DAT	E	<u> </u>	TITLE	SCALE
00	.11.22		SADDLE KIT	NTS
Α		00.06.01	NEW ISSUE	
В		00.11.22	ADD D2707-041 OPTION	

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION .
BELL 205/ 212 /412	D205-634-011
/) 污	D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE **FOLLOWING TABLE (REF):**

DAGTAUMADED	1//10000	2005 004 044	
PART NUMBER	K10003	D205-634-011	D204-635-011
		D205-634-015	
D205-641-011	1	1	1
D2570	16	16	. 16
D2571	1	1	. 1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	- 1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	•2
D2707-041 (or D2968-041)	1	1	• 1
AN4-51A	8	8	. 8
AN4-6A	16	16	16
AN6-12A	8	8	. 8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1 .
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

PURN TO ENG INE - 91 -UNICONTROL - O CUPY POMER SUBJECT TO WITHO STICE WORK CROEF

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_1 Dart Aerospace Ltd. Wednesday, 1/25/2006 1:22:00 PM User. Kim Johnston **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : SADDLE KIT Job Number : 25618 **Estimate Number** : 10532 P.O. Number Part Number : K10003 · K10003 REV B This Issue : 1/25/2006 S.O. No. : **Drawing Number** Prsht Rev. : NC : N/A Project Number First Issue : // : SMALL /MED FAB : B Type **Drawing Revision** : 25617 **Previous Run** Material Due Date : 2/20/2006 Qty: Each 6 Um: Written By Checked & Approved By Comment : Est: 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: DOCUMENT CONTROL 1.0 DC Comment: DOCUMENT CONTROL 06-0223 Photocopy bluefile and type labels per PPP K10003CHG004 for D205-634-011 and D204-635-011 2.0 D2570 Comment: Qty.: 24.0000 Each(s)/Unit Total: 144.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 24 D2570 Bushing 3.0 D2571 Saddle, Fwd, Out REFERENCE ONLY Comment: Qty.: 1.0000 Each(s)/Unit Total; 6.0000 Each(s) Saddle, Fwd, Out Pick: Qty Part Number Batch Description D2571 Saddle 1 4.0 D2572 -Saddle, Fwd, In Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Saddle, Fwd, In Pick:

Qty

1

Part Number

D2572

Description

Saddle

Batch